

Work Order ID: 93874

\*93874\*

Page 1

Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *12-11-27* Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3274

D

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

DAS  
06  
8-03

*13/5/11* *dg* *4H* *MLS* *13-5-1*

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\*93874\*

Page 2

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Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

\*110\*

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding -> CF 12-12-05

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M122854/M122357

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 12-11-29

CF 12-12-05  
BE 12-12-06

SAD 13-01-10

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\*93874\*

Page 3

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID               | Operation<br>Description                                  | Set Up/<br>Run Hours     | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|----------------------------------------------|-----------------------------------------------------------|--------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 114<br>*114*<br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>0.00<br>13.41.10 |         |        |              | 1             |               |                  |                |
| 116<br>*116*<br>QC<br>Quality Control        | QC10- Inspect visual per QSI004- ground welds<br><br>Memo | 0.00<br>0.00<br>13.1.10  |         |        |              | 1             |               |                  |                |
| 120<br>*120*<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo       | 0.00<br>0.00             |         |        |              | 1             | 76            | 13.1.11          |                |

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Page 4

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

\*130\*

QC

Memo

0.00

Quality Control

① SAD 13-01-14

150

0.00

\*150\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 M123353

Sikaflex expire date: 13-6-22

Start: 13-1-15 Time: 10:45

Finish: 13-1-21 Time: 1:00

(Adhere for 12 hours)

> CF 13-1-14

> CF 13-1-15

# Work Order ID 93874

\*93874\*

Page 5

Item ID: D206-642-541

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 27/11/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                                          | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            | QC5- Inspect part completeness to step on W/O                                                                                                                                     | 0.00                 |         |        |              |               |               |                  |                |
| *160*                          |                                                                                                                                                                                   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                                                                                                              | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                                                                                                   |                      |         |        |              |               |               |                  |                |
| 170                            |                                                                                                                                                                                   | 0.00                 |         |        |              |               |               |                  |                |
| *170*                          | Skidtubes                                                                                                                                                                         |                      |         |        |              |               |               |                  |                |
| Skidtubes                      | Memo                                                                                                                                                                              | 0.00                 |         |        |              |               |               |                  |                |
| Skidtubes                      | 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.                                         |                      |         |        |              |               |               |                  |                |
|                                | 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur                                                                                                   |                      |         |        |              |               |               |                  |                |
|                                | 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE<br>DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)<br>REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES |                      |         |        |              |               |               |                  |                |
|                                | 4- Countersink crossbolt spacer holes as per Dwg D3274                                                                                                                            |                      |         |        |              |               |               |                  |                |
|                                | 5- prepare for welding                                                                                                                                                            |                      |         |        |              |               |               |                  |                |



13-1-16

CF 13-1-17

# Work Order ID 93874

\*93874\*

Page 6

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

4.5°

3.0°

\*180\*

QC

Memo

0.00

Quality Control

1

0

13-01-21

DAS  
18

190

Skidtubes

0.00

\*190\*

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod M122130

13-01-21

3-Grind cross bolt welds flush as per Dwg D3274.

→ CF 13-1-22

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

- De 13/01/22

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\*93874\*

Page 7

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

\*210\*

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

\*220\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

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\*93874\*

Page 8

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                                                                                                                 | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230                            | White Gloss(Ref:4.3.5.1) per Q87005 4.3-Alum                                                                                                                                                                                                             | 0.00                 |         |        |              |               |               |                  |                |
| *230*                          |                                                                                                                                                                                                                                                          |                      |         |        |              |               |               |                  |                |
| Powdercoat                     | Memo                                                                                                                                                                                                                                                     | 0.00                 |         |        |              |               |               |                  |                |
| Powder Coating                 | START TIME: 11:50<br>OVEN TEMPERATURE: 320<br>FINISH TIME: 12:20                                                                                                                                                                                         |                      |         |        |              |               |               |                  |                |
| 240                            | QC3- Inspect Part Finish                                                                                                                                                                                                                                 | 0.00                 |         |        |              |               |               |                  |                |
| *240*                          |                                                                                                                                                                                                                                                          |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                                                                                                                                                                                     | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                                                                                                                                                                                                          |                      |         |        |              |               |               |                  |                |
| 250                            | HandFinishing                                                                                                                                                                                                                                            | 0.00                 |         |        |              |               |               |                  |                |
| *250*                          |                                                                                                                                                                                                                                                          |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                                                                                                                                                                                                                                                     | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 | 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.<br>A/RN/ALPS-PROCYON M122900<br>2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 M124958<br>Sikaflex expire date: 13/07 |                      |         |        |              |               |               |                  |                |

1 x 1 1/2 B-1-28

PTO

1 x 1 1/2 13/04/25

1 x 1 1/2 13/04/25



NCR: ☒ Yes ☐ No**WORK ORDER NON-CONFORMANCE / UPDATE**DQA: *[Signature]*

Date: 13/05/10

QA Closed: *[Signature]*

Date: 13/5/16

| Work Order: <u>93874</u><br>Part No. <u>D206-642-541</u><br>NCR No. <u>13-2558</u>                                                                                                                                                                                                                                                                                                                                                                                                                                          |         |      |     | <b>DISPOSITION</b><br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>AGAINST DEPARTMENT/PROCESS</b><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input checked="" type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                      |                        |                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|------|-----|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|------------------------|------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Date    | Step | Qty | Description of work order update or Non-conformance                                                                                                                                    | Initial Chief Eng                                                                                                                                                                                                                                                                                                                                                                                                                               | Action Description                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Sign & Date                          | Verification           | QC Inspector                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |  |
| Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Operator <input checked="" type="checkbox"/><br>Material <input type="checkbox"/><br>Setup <input type="checkbox"/><br>Other <input type="checkbox"/><br>Process <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Unapproved <input type="checkbox"/>                                                                                                                                   | 13/2/26 | 230  | +1  | Found at Qc 3<br>Powder coat inspection<br>that skid tube had<br>two blisters on the<br>top next to the square<br>R.C. Duct when moving to<br>cool.                                    | DAS 16<br>9-2<br>057042<br>13/2/26                                                                                                                                                                                                                                                                                                                                                                                                              | chain entire tube<br>And Re Powder coat<br>start temp<br>Fin temp 11:50<br>As per 052005 320<br>Re Powder coat 12-20<br>13/2/26                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 7/6<br>13/4/11<br>13/4/23<br>13/4/23 | DAS 27<br>2-2<br>15426 | DAS 16<br>9-2<br>057042<br>13/2/26 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |  |
| <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |         |      |     |                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                      |                        |                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |         |      |     |                                                                                                                                                                                        | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                      |                        |                                    | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |  |  |  |  | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |  |  |  |  |
| <i>[Signature]</i> / <i>[Signature]</i>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |         |      |     |                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                      |                        |                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |  |

# Work Order ID 93874

\*93874\*

Page 9

Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

\*260\*

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

1 x 134-26

270

HAND FINISHING RESOURCE #1

0.00

\*270\*

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 124958

Sikaflex expire date: 13107

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N10

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 124958

Sikaflex expire date: 13107

1 x 11104126

# Work Order ID 93874

\*93874\*

Page 10

Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

\*280\*

QC

Memo

0.00

Quality Control

290

Identify as per dwg & Stock Location:

0.00

\*290\*

Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

\*300\*

QC

Memo

0.00

Quality Control

13/5/34

13-5-1

13-5-2

# Picklist Print

November-27-12 8:32:09 AM

Page 1  
10

Work Order ID: 93874

\*93874\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM  
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
IPP Rev:F 08-06-02 add comment DD verified by:EC  
IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-190                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 83.0000        | 1           |              |               |                |        |
| *D2600-1-190*                   |                        |               |             |                     |                  |                 |                    |                | **          |              |               | 12-11-29       |        |
| Extrusion Round 3" 206          |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL     | 43      |          |
| 69622    | 43      |          |
| LG       | 40      |          |
| 76912    | 40      |          |

|              |    |     |      |         |   |    |
|--------------|----|-----|------|---------|---|----|
| Manufactured | No | 110 | Each | 21.0000 | 1 | ** |
|--------------|----|-----|------|---------|---|----|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG002    | 21      |          |
| 52511    | 1       |          |
| 52647    | 20      |          |

|              |    |     |      |        |   |    |
|--------------|----|-----|------|--------|---|----|
| Manufactured | No | 150 | Each | 4.0000 | 1 | ** |
|--------------|----|-----|------|--------|---|----|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG       | 4       |          |
| 91988    | 4       |          |

B93487

D3285-1  
\*D3285-1\*  
Cap

D3282-041  
\*D3282-041\*  
Float Web (206L/407)

AE 12-06

CF 13-1-15

# Picklist Print

November-27-12 8:32:09 AM

Page 2

Work Order ID: 93874

**\*93874\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

202.0000

12

12

**\*D2649\***

Cross Bolt Spacer

**\*\***

*BE-13-01-21*  
*B93663 x12*

## Location

## Loc Qty

## Loc Code

LG001

1

90967

1

LG002

201

82813

40

85586

4

86912

3

88529

15

90333

7

90497

6

91632

120

92194

6

D3275-1

Manufactured No

190

Each

145.0000

12

12

**\*D3275-1\***

Crossbolt Spacer

**\*\***

*BE-13-01-21*

## Location

## Loc Qty

## Loc Code

LG002

145

66930

1

85418

1

87713

143

*12*

# Picklist Print

November-27-12 8:32:09 AM

Page 3

Work Order ID: 93874

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*93874\*

\*D206-642-541\*

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1.640.000

2

2

\*\*

11/14/25

\*CR3212-4-03\*

Cherry Rivet

## Location

## Loc Qty

## Loc Code

ST328

804

114859

210

123265

500

123301

94

ST331

836

110139

2

119017

834

D3415-041

Manufactured

No

250

Each

13.0000

1

1

\*\*

11/14/25

\*D3415-041\*

Nut Plate

## Location

## Loc Qty

## Loc Code

ST044

13

82151

13

CCR264SS3-3

Purchased

No

250

Each

468.0000

2

2

\*\*

11/14/25

\*CCR264SS3-3\*

Cherry Rivet

## Location

## Loc Qty

## Loc Code

ST327

468

117849

5

119017

188

122973

73

123265

202

# Picklist Print

November-27-12 8:32:09 AM

Page 4

Work Order ID: 93874

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

**\*93874\***

**\*D206-642-541\***

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

389.0000

78

78

**\*AI S4-1032-130\***

Insert

\*\*

11 13/04/25

Location

Loc Qty

Loc Code

ST279

389

124163

X78

119084

116

120671

89

120807

36

120837

8

121269

140

D3536-15

Manufactured

No

270

Each

21.0000

1

1

**\*D3536-15\***

Gasket

\*\*

11 13/04/25

Location

Loc Qty

Loc Code

FG

2

85604

2

1398931

X1

FP001

17

86253

9

93199

8

FP002

2

73318

1

81343

1

D3536-23

Manufactured

No

270

Each

24.0000

1

1

**\*D3536-23\***

Gasket

\*\*

11 13/04/25

Location

Loc Qty

Loc Code

FG

2

85295

2

1396998

X1

FP002

22

74510

1

83377

1

89928

20

# Picklist Print

November-27-12 8:32:09 AM

Page 5

Work Order ID: 93874

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*93874\*

\*D206-642-541\*

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35

Manufactured No

270

Each

26.0000

1

1

\*D3536-35\*

Gasket

\*\*

all 13/04/25

## Location

## Loc Qty

## Loc Code

FG

2

1398371

Y1

89650

2

FP001

1

86251

1

FP002

23

82065

2

90843

8

90844

13

D3536-39

Manufactured No

270

Each

21.0000

1

1

\*D3536-39\*

Gasket

\*\*

all 13/04/25

## Location

## Loc Qty

## Loc Code

FP001

21

1393911

Y1

82252

1

85870

7

92160

13

D3535-15

Manufactured No

270

Each

41.0000

1

1

\*D3535-15\*

Wearshoe

\*\*

all 13/04/25

## Location

## Loc Qty

## Loc Code

FP001

41

85291

2

86230

10

93045

29

X1



# Picklist Print

November-27-12 8:32:09 AM

Page 6

Work Order ID: 93874

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*93874\*

\*D206-642-541\*

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-35

Manufactured No

270

Each

22.0000

1

1

\*D3535-35\*

Wearshoe

\*\*

13/04/25

## Location

## Loc Qty

## Loc Code

FP001

22

67598

1

70815

1

79849

1

86191

1

90092

5

92343

13

1397179

X1

D3535-39

Manufactured No

270

Each

21.0000

1

1

\*D3535-39\*

Wearshoe

\*\*

13/04/25

## Location

## Loc Qty

## Loc Code

FP001

21

69759

1

81359

4

85869

6

87182

10

1393206

X1

D3535-23

Manufactured No

270

Each

40.0000

1

1

\*D3535-23\*

Wearshoe

\*\*

13/04/25

## Location

## Loc Qty

## Loc Code

FP001

40

86232

1

89963

13

90518

13

93181

13

1396125

X1

# Picklist Print

November-27-12 8:32:09 AM

Page 7

Work Order ID: 93874

\*93874\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

18.0000

1

\*D3537-3\*

Wearpad

\*\*

11 13/04/25

## Location

## Loc Qty

## Loc Code

FG

8

1398447

11

86237

8

FP002

10

78836

1

90147

9

D3537-1

Manufactured No

270

Each

71.0000

9

\*D3537-1\*

Wearpad

\*\*

11 13/04/25

## Location

## Loc Qty

## Loc Code

FP001

57

1398495

14

91645

33

91668

24

FP002

14

83254

1

83255

3

87697

1

88562

9

AN960C10L

NAS1149C0332  
R

Purchased

No

270

Each

21.0000

80

80

\*AN960C10I \* ✓

washer

11125268

\*\*

(x50) 11 13/04/25

## Location

## Loc Qty

## Loc Code

ST245

21

107534

21

AN960C416

NAS1149C0463  
R

Purchased

No

270

Each

0.0000

1

1

\*AN960C416\* ✓

washer

1119097 \*\*

(x1) 11 13/04/25

November-27-12 8:32:09 AM

Shop.Packet Print

Page 7

# Picklist Print

November-27-12 8:32:09 AM

Page 8

Work Order ID: 93874

**\*93874\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,237.000

2

2

**\*D3672-1\***

Phenolic Washer

\*\*

13/04/25

## Location

## Loc Qty

## Loc Code

FG

10

85222

10

x2

FP001

2

80369

2

ST061

1225

72229

4

76277

13

83608

460

85222

268

91325

480

AN3C4A

Purchased

No

270

Each

2,953.000

80

80

**\*AN3C4A\***

BOLT

\*\*

13/04/25

## Location

## Loc Qty

## Loc Code

FG

20

122814

20

ST350

2751

123759

2751

x80

ST513

182

120187

31

120521

28

120769

38

121205

61

121556

8

122151

2

122416

4

122814

2

123021

8

# Picklist Print

November-27-12 8:32:09 AM

Page 9

Work Order ID: 93874

**\*93874\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

443.0000

1

1

**\*AN4C5A\***

BOLT

\*\*

*13/04/24*

Location

Loc Qty

Loc Code

ST355

443

112243

129

119017

6

122599

108

123265

200

*X1*

D2646

Manufactured

No

270

Each

152.0000

1

1

**\*D2646\***

Aft Cap

\*\*

*13/04/28*

Location

Loc Qty

Loc Code

FG

2

90495

2

FP002

150

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

79562

2

81974

10

85443

2

85848

4

90495

16

91189

100

*X1*

# Picklist Print

November-27-12 8:32:09 AM

Page 10

Work Order ID: 93874

\*93874\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

16.0000

1

\*D3413-1\*

\*\*

del 13/04/25

Ring

Location

Loc Qty

Loc Code

ST421

12

1391117

✓

88025

10

90506

2

ST464

4

80224

4



|                  |                |                                              |                        |
|------------------|----------------|----------------------------------------------|------------------------|
| DESIGN<br>CP     | DRAWN BY<br>PH | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3274                         | REV. D<br>SHEET 1 OF 4 |
| DATE<br>06.12.19 |                | TITLE<br>SKIDTUBE ASSEMBLY<br>SCALE<br>NTS   |                        |
| A                | 04.03.15       | NEW ISSUE                                    |                        |
| B                | 04.08.09       | MOVE SADDLE HOLE: 42.14 WAS 42.76            |                        |
| C                | 05.03.16       | ADD -043; NEW INSERTS                        |                        |
| D                | 06.12.19       | NEW INSERTS, SS WEARSHOE + GASKET            |                        |

RELEASED  
07.02.12  
DEO ATTACHED

| Qty<br>-041 | Qty<br>-043 | Part Number   | Description                                             |
|-------------|-------------|---------------|---------------------------------------------------------|
| X           |             | D3274-041     | SKIDTUBE ASSEMBLY                                       |
|             | X           | D3274-043     | SKIDTUBE ASSEMBLY                                       |
| 1           | 1           | D2600-1-240   | EXTRUSION                                               |
| 1           | 1           | D2646         | AFT CAP                                                 |
| 12          | 12          | D2649         | CROSS BOLT SPACER                                       |
| 12          | 37          | D3275-1       | CROSS BOLT SPACER                                       |
| 1           | 1           | D3282-041     | FLOAT WEB                                               |
| 1           | 1           | D3285-1       | CAP                                                     |
| 1           | 1           | D3413-1       | RING                                                    |
| 1           | 1           | D3415-041     | NUT PLATE                                               |
| 1           | 1           | D3535-15      | WEARSHOE                                                |
| 1           | 1           | D3535-23      | WEARSHOE                                                |
| 1           | 1           | D3535-35      | WEARSHOE                                                |
| 1           | 1           | D3535-39      | WEARSHOE                                                |
| 1           | 1           | D3536-15      | GASKET                                                  |
| 1           | 1           | D3536-23      | GASKET                                                  |
| 1           | 1           | D3536-35      | GASKET                                                  |
| 1           | 1           | D3536-39      | GASKET                                                  |
| 9           | 9           | D3537-1       | WEARPAD                                                 |
| 1           | 1           | D3537-3       | WEARPAD                                                 |
| 78          | 78          | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80          | 80          | AN3C4A        | BOLT                                                    |
| 1           | 1           | AN4C5A        | BOLT                                                    |
| 1           | 1           | AN960C416     | WASHER                                                  |
| 80          | 80          | AN960C10L     | WASHER                                                  |
| 2           | 2           | CCR264SS3-3   | RIVET                                                   |
| 2           | 2           | CR3212-4-03   | RIVET                                                   |
| 2           | 2           | NAS1515H3L    | WASHER                                                  |

#### GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

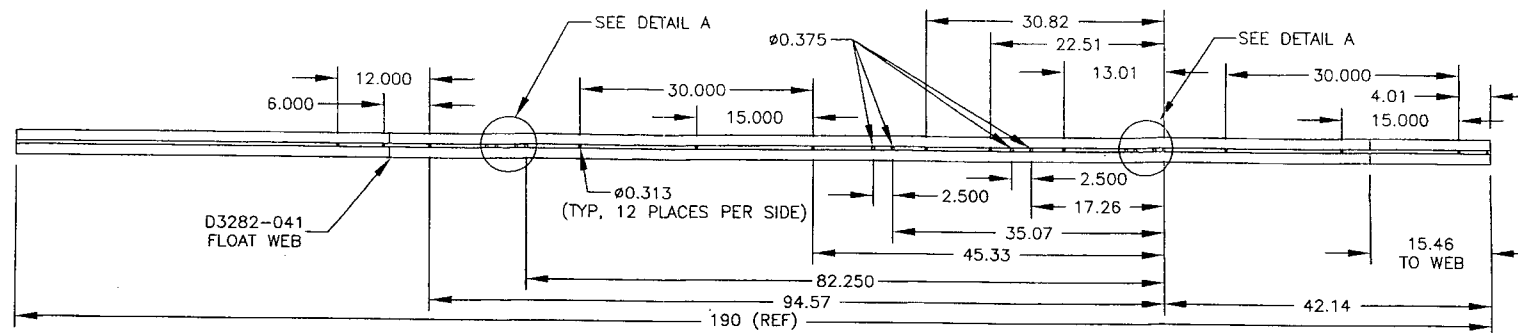
12-11-23  
ML5  
93894  
TIER  
OFFICE  
INDUMENT  
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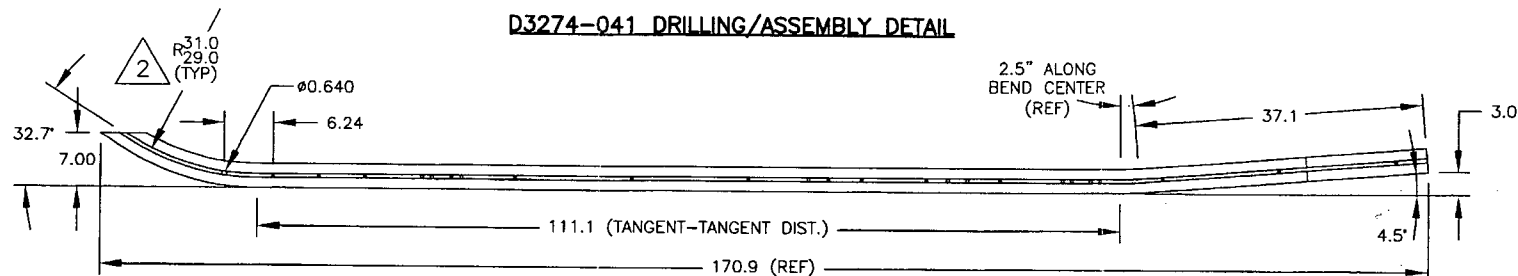
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93874

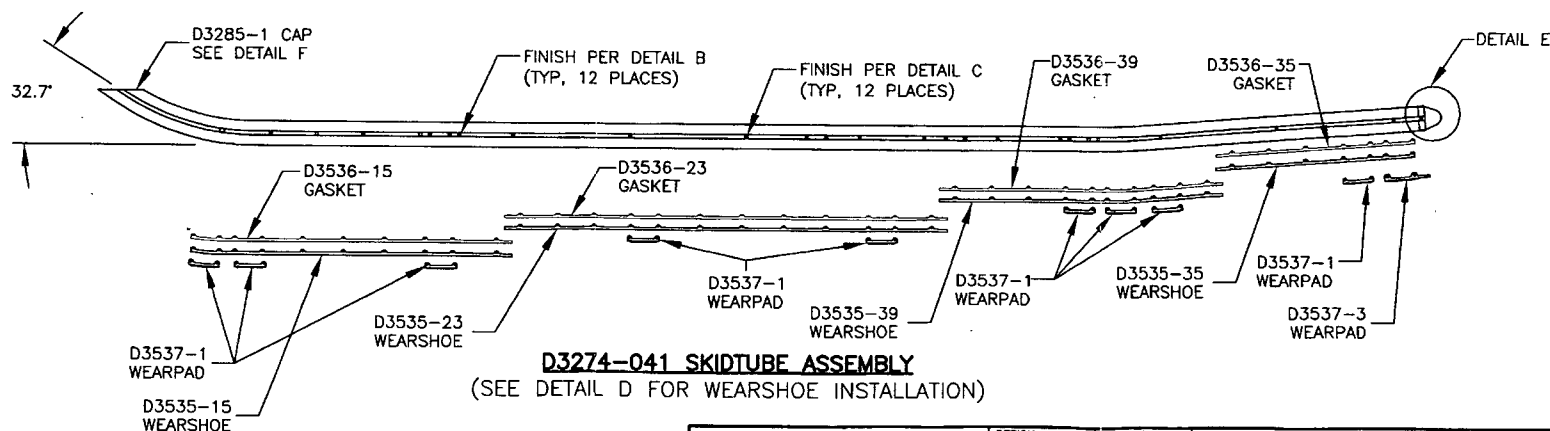
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

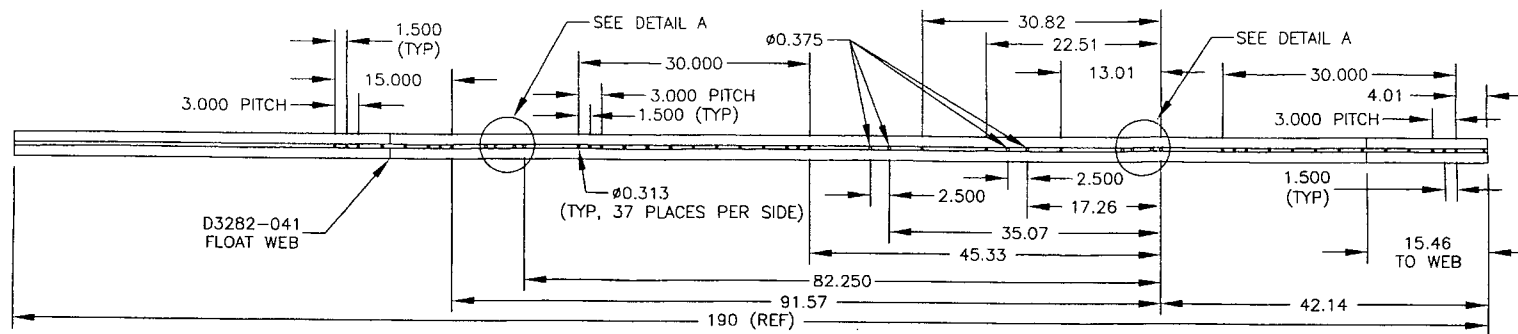
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07.02.12

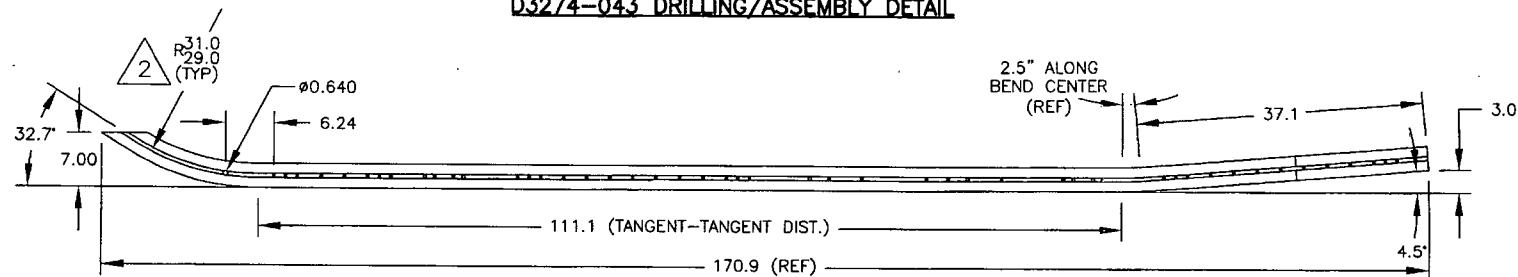
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| CHECKED                                                                                                                                                                                                                             | APPROVED | DATE     | DRAWING NO.       | REV. D                                                   |
| #                                                                                                                                                                                                                                   | #        | 06.12.19 | D3274             | SHEET 2 OF 4                                             |
|                                                                                                                                                                                                                                     |          |          | TITLE             | SCALE                                                    |
|                                                                                                                                                                                                                                     |          |          | SKIDTUBE ASSEMBLY | 1:15                                                     |

93874

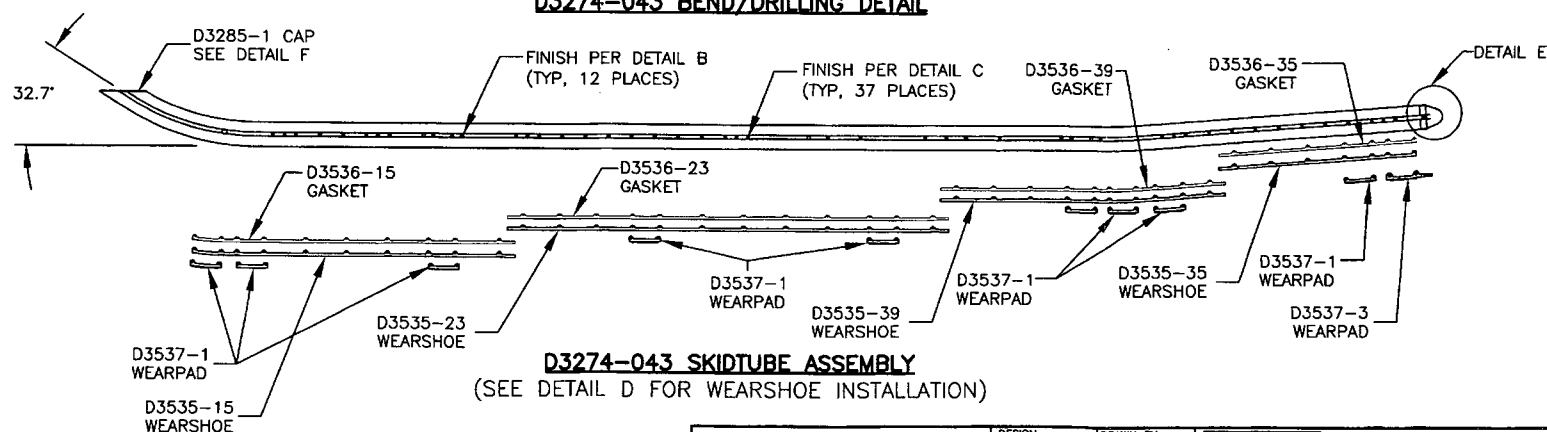
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

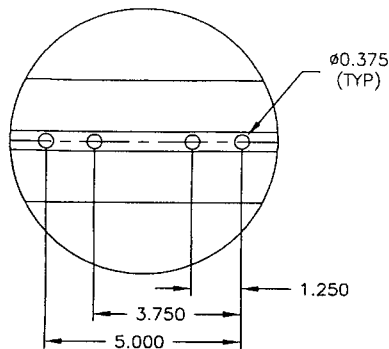
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07.02.12

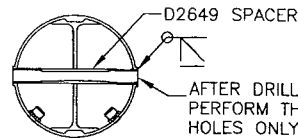
|                                              |          |          |                   |                                              |        |
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| CHECKED                                      | CP       | APPROVED | PH                | DRAWING NO.                                  | REV. D |
| DATE                                         | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | SHEET 3 OF 4                                 | SCALE  |
|                                              |          |          |                   | 1:15                                         |        |



**DETAIL A: DRILL DETAIL**

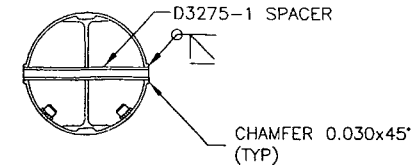


**DETAIL B**  
FOR Ø0.375 HOLES ONLY

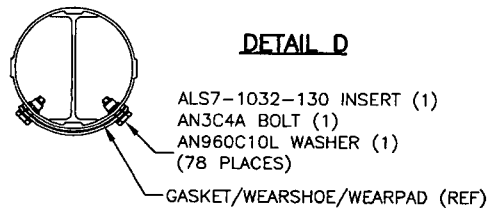


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO Ø0.313x0.75 DEEP

**DETAIL C**  
FOR Ø0.313 HOLES ONLY



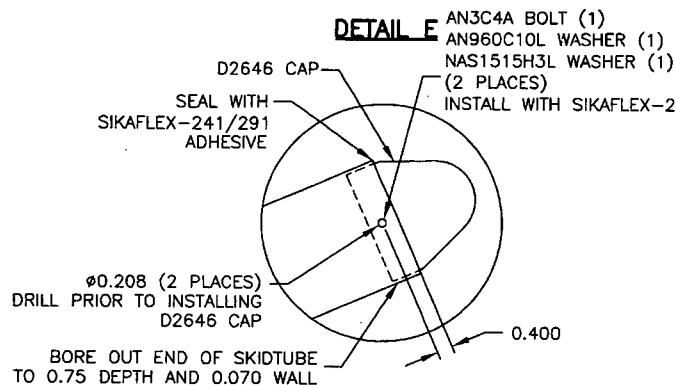
**DETAIL D**



- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

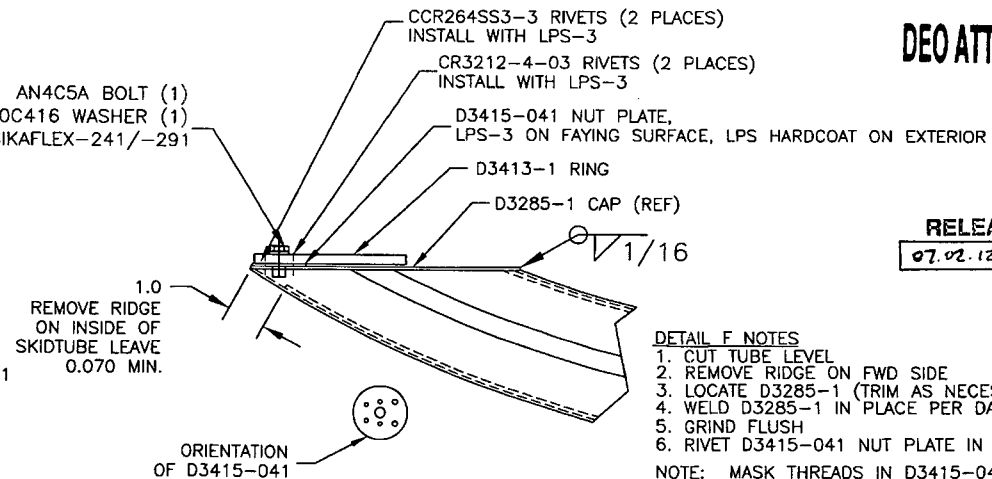
GASKET/WEARSHOE/WEARPAD (REF)

**DETAIL E**



- AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

**DETAIL F: END FINISHING DETAIL**



- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

**RELEASED**  
07.02.12

|                                                                                                                                                                                                                                                    |          |          |                              |                                              |        |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------|------------------------------|----------------------------------------------|--------|
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| CHECKED                                                                                                                                                                                                                                            | APPROVED | DATE     | TITLE                        |                                              |        |
|                                                                                                                                                                                                                                                    |          | 06.12.19 | SKIDTUBE ASSEMBLY            |                                              |        |
|                                                                                                                                                                                                                                                    |          |          | SHEET 4 OF 4<br>SCALE<br>1:3 |                                              |        |

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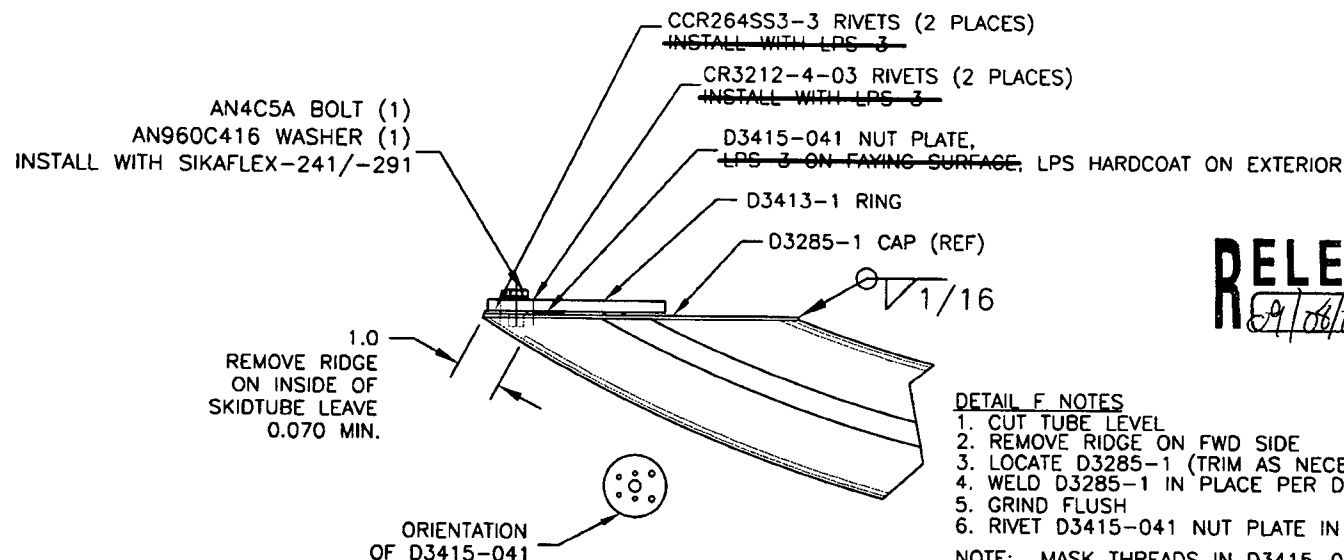
|                      |                               |                                  |                                |                                |                           |              |
|----------------------|-------------------------------|----------------------------------|--------------------------------|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3274 | TITLE<br>SKIDTUBE ASSEMBLY    | REV. D                           | <b>DART AEROSPACE USA, INC</b> | D.E.O. NO.<br>D3274-D-1        | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>UP</i>   | CHECKED<br><i>[Signature]</i> | MFG. APPR.<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DE APPR.<br><i>[Signature]</i> |                           |              |
| DATE<br>09.06.17     | DATE<br>09.06.23              | DATE<br>09/06/23                 | DATE<br>09/06/23               | DATE<br>09.06.23               |                           |              |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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